

Work Order ID 72323

Friday, July 22, 2011 11:21:21 AM



Page 1

Item ID: D4306-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 7/22/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 7-27-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4306	C

100 Weld per dwg A/R S.S. rod Batch: 0.00



Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D4306-5
- 4- Drill and chamfer holes as per dwg D4306-5 using DT9710
- 5- weld bushing as per dwg D4306
- 6- grind welds flush

Handwritten: Cpl 11.07.16 (X4)

Handwritten: 11/10/06 (4)

110 QC6- Inspect dimensions to drawing 0.00



QC

Quality Control

Memo

0.00

Handwritten: S. L. L. L. L. L.

Handwritten: (X4)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 2

[illegible]**Setup Start**[illegible]

Stop

[illegible][illegible]**Cust Item ID:**

Customer:

Run Start

[illegible]

Date:

Stop

**SPC (Y/N):**

Date:

**Insp.
Stamp**

0.00

[illegible]

0.00

QC

Memo

Quality Control

0.00

[illegible]

0.00

Packaging

Memo

Packaging

0.00

[illegible]

0.00

OC

Memo

Quality Control

74.

By 11/10/06 (4x)

12/10/11 *JA*
MF 11-10-06

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Picklist Print

Friday, July 22, 2011 11:21:27 AM

Page 1

Work Order ID: 72323

Parent Item: D4306-045

Parent Item Name: Rib Assembly



Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1		Manufactured	No					100	Each	137.0000	4	16	
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Bushing

Location

Loc Qty

Loc Code

WA	135	
69202	135	
WA005	2	
66489	2	

M304TS0.750W.049		Purchased	No					100	f	285.0645	4.166	17.54105	
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304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018	108.325209	
117690	4.372109	
117775	103.9531	
MAT034	7.5904	
117337	7.5904	
WA	169.14894	
118184	169.14894	



B72316 16x

25 11/10/06



CP 11-09-10

m118880 → 17.5410

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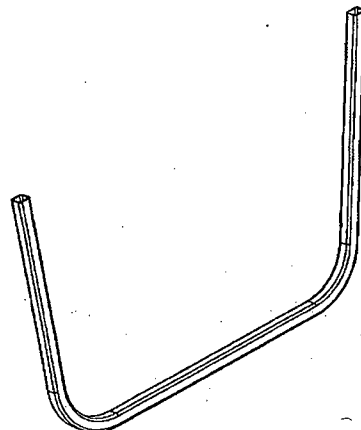
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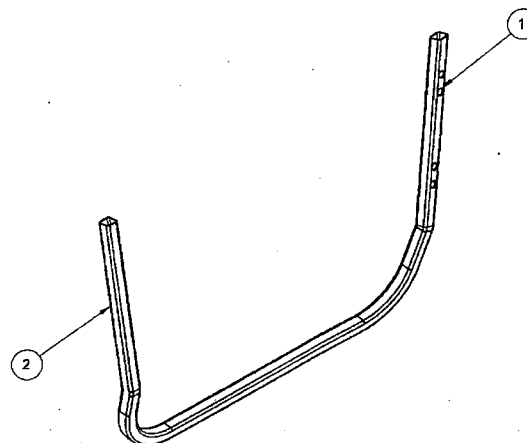
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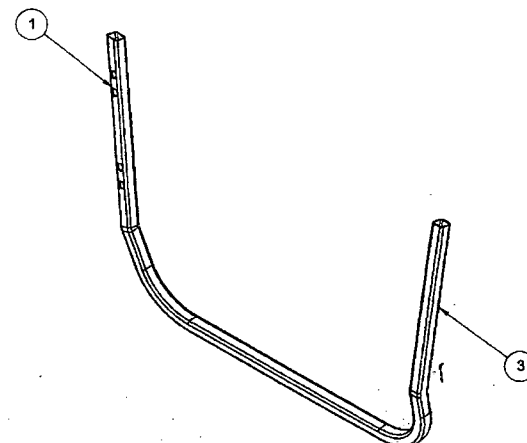
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



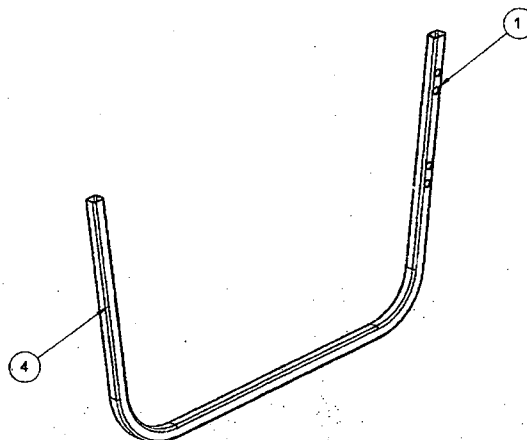
D4306-1 RIB



D4306-043 RIB ASSY, LH



D4306-044 RIB ASSY, RH



D4306-045 RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 42323

REV.	DESCRIPTION	BY	DATE
C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4'-6); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-5)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4306	SHEET 1 OF 8
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	RIB	NTS
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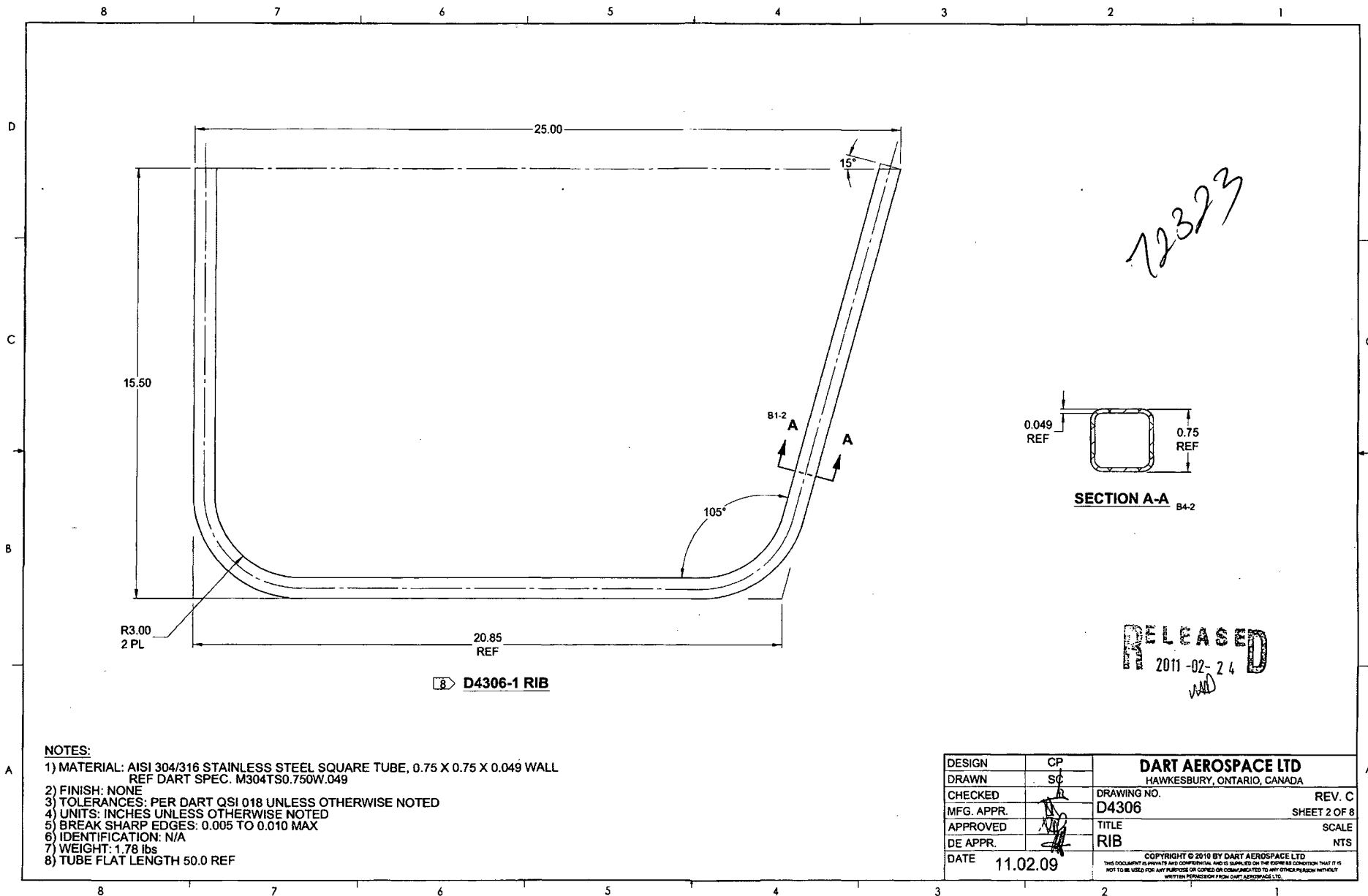
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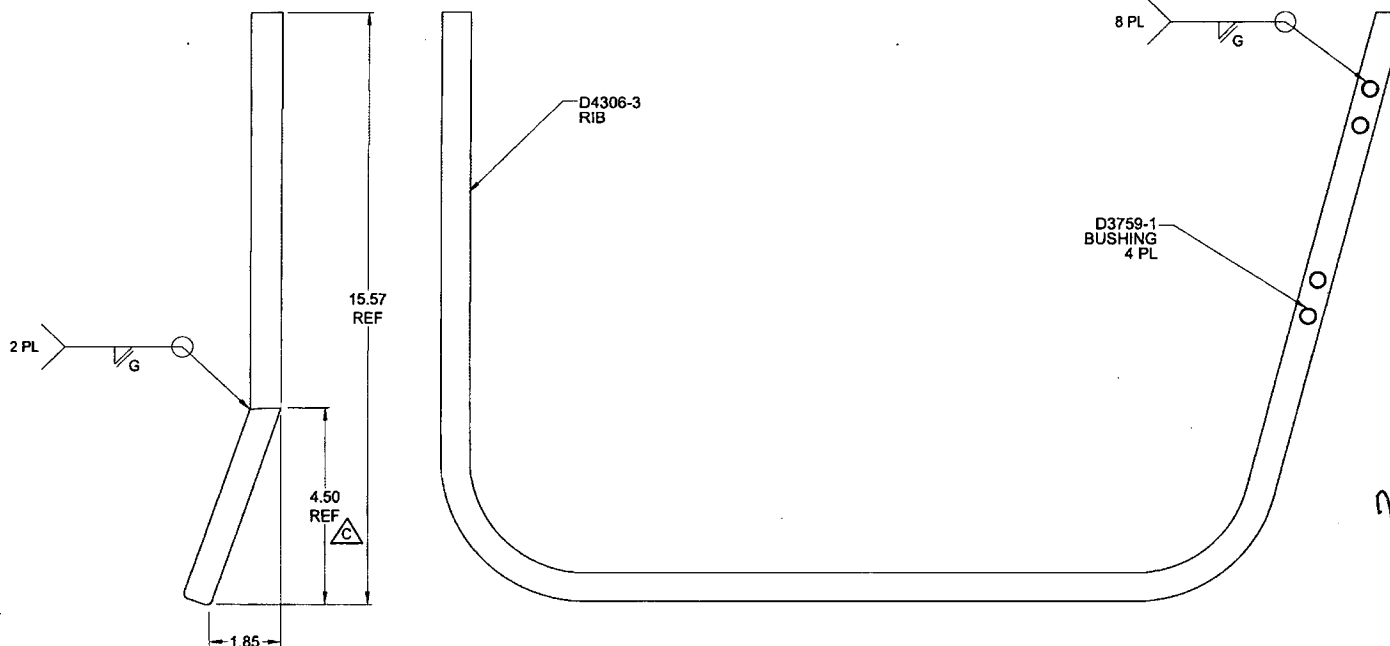
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D4306-043 RIB ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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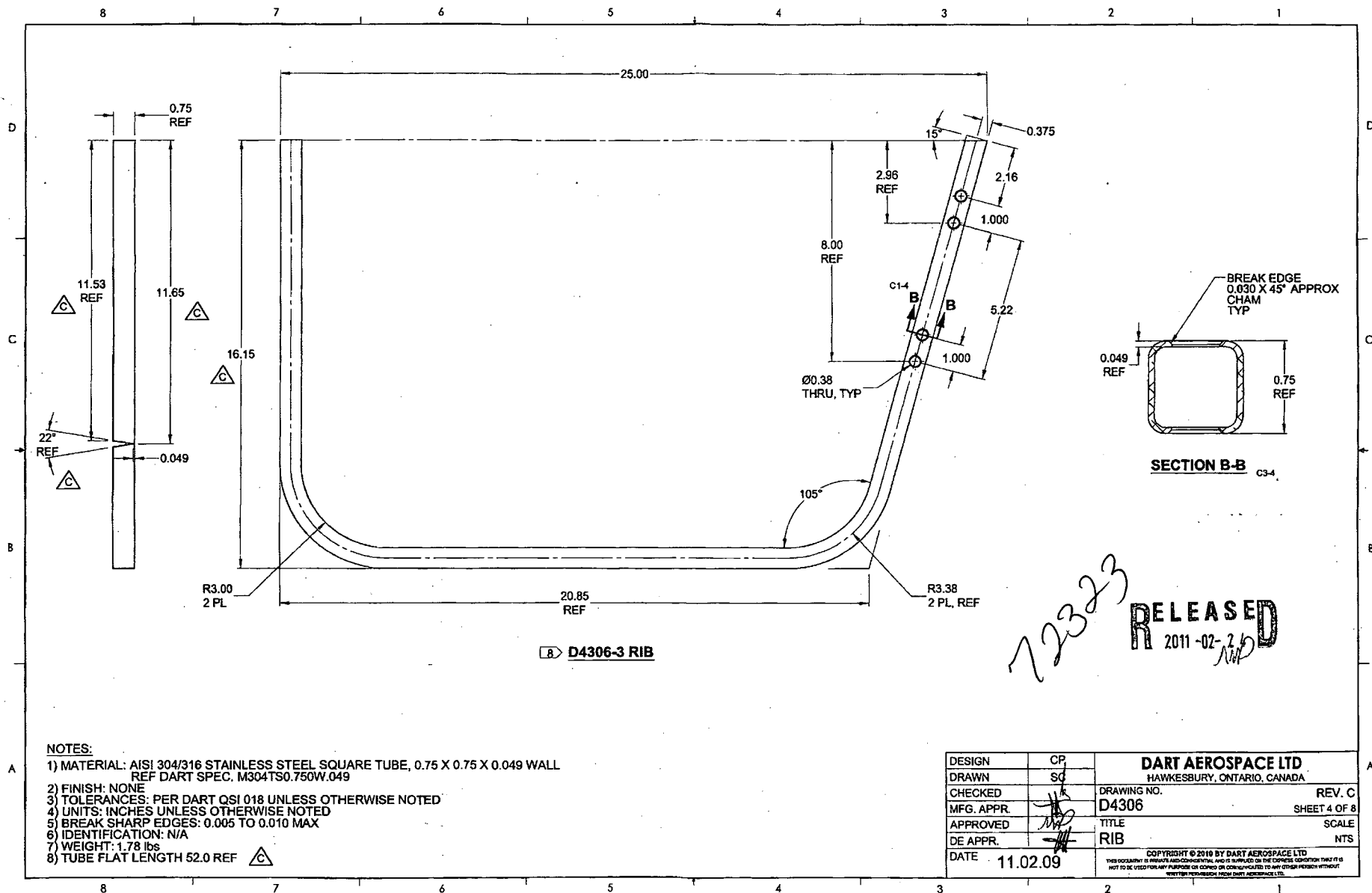
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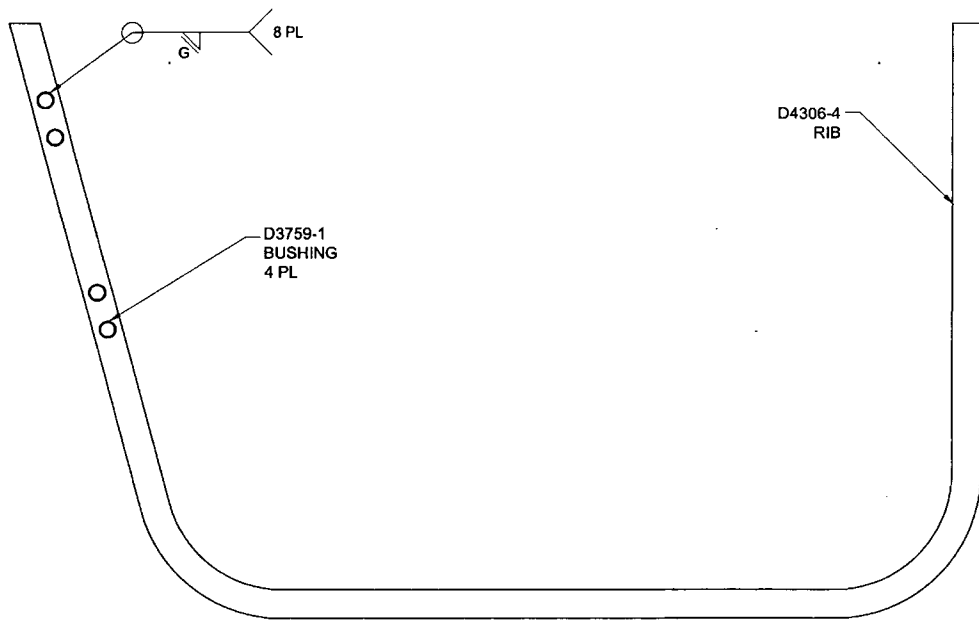
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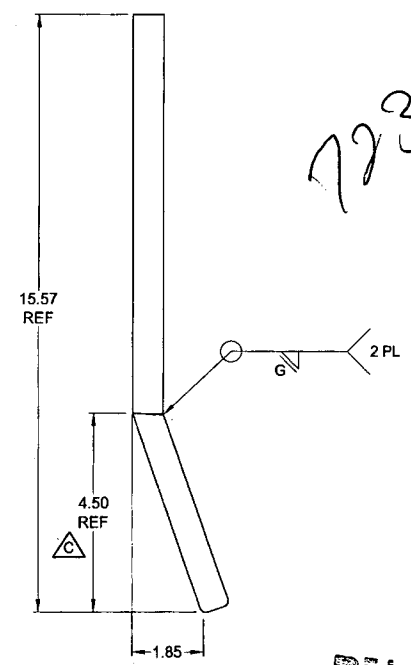
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D
C
B
A



D4306-044 RIB ASSY, RH



72323

RELEASED
2011-02-24
W

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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8 7 6 5 4 3 2 1

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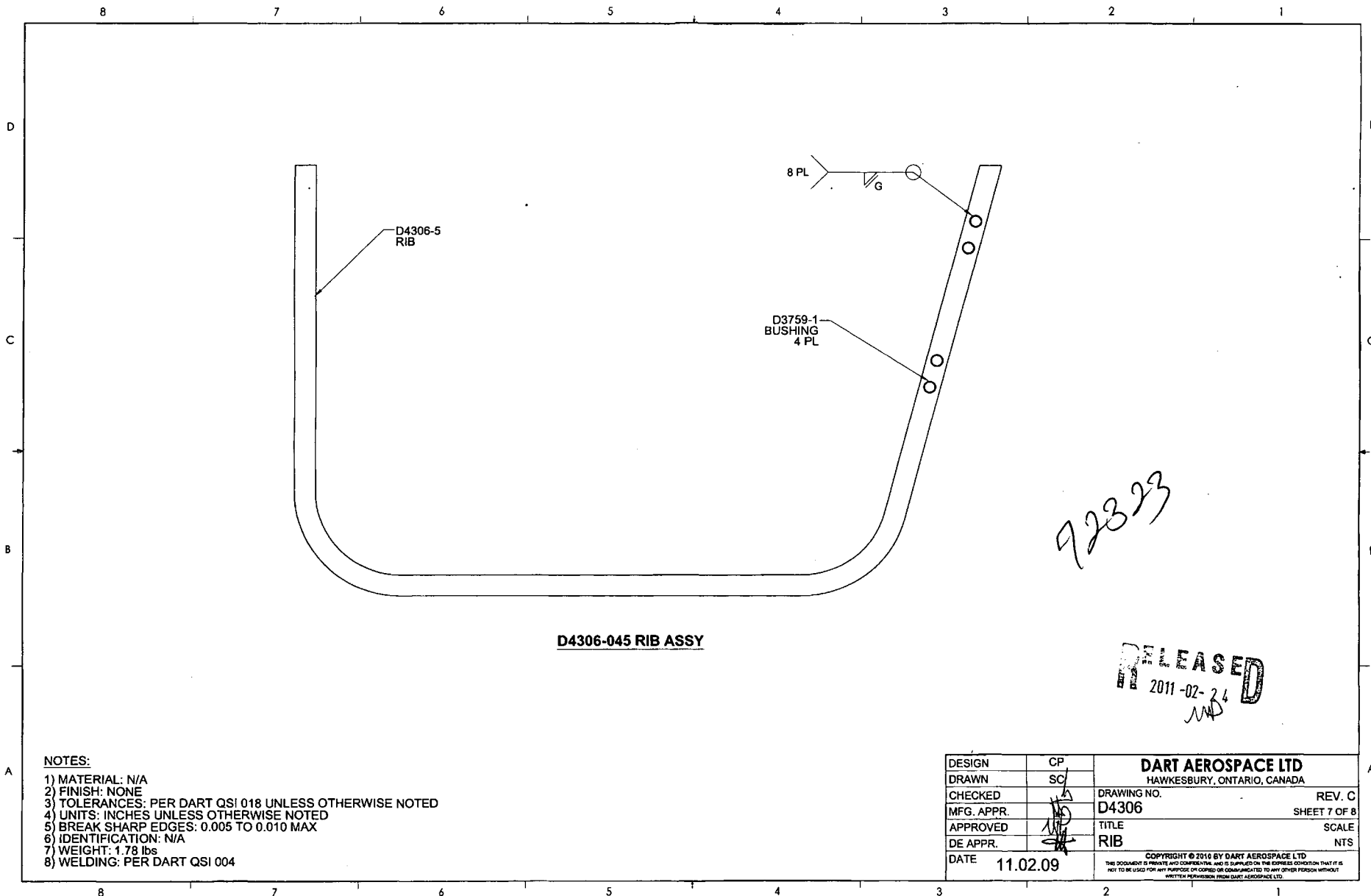
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D4306-045 RIB ASSY

RELEASED
2011-02-24
WMB

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- 1) MATERIAL: N/A
- 2) FINISH: NONE
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